	er ID 101411 4, 2013 2:48:18 PM			*101		Page						
Revision ID:	D2171 · Clamp		A	ccept	*N900	040	100)*	Setup Sta		NS	S1*
Required Date:	5/13/2013 Req'd RMA RA111528 ~ 1	_	*2* *2*		Cust Item I Customer:		AR001					17
Approvals:	Process Plan: QC:			Tooling: SPC (Y/N):	Date:					art 4	'NF 'NF	₹1* ₹2*
Sequence ID/ Work Center II	Operat Descrip			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Reject Qty	•	ect nber	Insp. Stamp
Draw Nbr	Revision Nb	r .										
D2171	Rev D											
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100 QC Quality Control		Memo INSPECT RAI	11528 D2171 X 2 B#9785	0.00513loslo	P					·		
		PARTS ARE O	OOD									

110

Identify as per dwg & Stock Location: \$34,000

ID AND STOCK UNDER NEW BATCH

110 Packaging

Packaging

ckaging

Memo

NUMBER

0.00

/5/3/1/2

DQA:		_ Date:			$ \sim$ \sim \sim \sim \sim \sim \sim \sim \sim \sim										
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE										
QA Closed.		Date.			Work Order update only										
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS								
					Rework	1		Skid-tube Crosstube	e		Engineering				
Part N	o	_			Scrap			Machining Small Fal	<u> </u>	Pro	d. Eng. Coor.	Quality			
					Use-as-is		Therr	noforming Finishin	g	Rec/Sto	re/Packaging	Other			
NCR No.					Suspected Unapproved]		Large Fab Composite	e]	Supplier				
Root				Desci	ription of work order update		Initial	Action		Sign &					
Cause	Date	Step	Qty		or non-conformance	i i	ief Eng			Date	Verification	QC Inspector			
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						FA	ULT CAT	regory				· · · · · ·			
Landin	g Gear				General					-					
ļ_	Bending				Bend		Folio/P	rogram		Outside Dim	ensions	Pressure/Forced			
	Centre Not Concentric				BOM/Route		Grain			Over/Under	tolerance	Set-up			
	Cracks				Broken/Damage/Defect		Hardwa	re	L	Part Incorred	t	Temperature/Cure			
	Crimp/Kink/Ripple/Wave				Burrs		Inspect	on Incomplete/Unqualified		Part Lost/Mi	ssing	Weld			
	Cuffs				Contamination	<u> </u>	Instruct	ions Incomplete/Unclear		Part Moved		Wrong Stock Pulled			
	Crushing				Countersink		Misalig	ned/off center		Positioned V		_			
1	Heat Treat				Cut Too Short		Mislabe	led		Power Loss/	Surge	Other			
	 1. '	on Strip in	Tube		Drawing		Misread	1							
	Marks/C				Drill Holes		Off-set								
		Sequence		_	Finish		Out of 0	Calibration							
ŀ	Wave/Tu	vist in Tub	e		Fit/Function	1 -	Out of 9								

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Work Orde Tuesday, June 0				*101411*									
Item ID: Revision ID: Item Name:	D2171 Clamp			Accept	*N900	04 0	100	* \$	Setup Sta	I A	S1*		
Start Date: Required Date: Reference:	5/10/2013 5/13/2013 RMA RA11	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	OAR001			10	. 17			
Approvals:	Process Pl QC:	an:	Date:		Date:			F	Run Sta Sto	1/1	R1* R2*		
Sequence ID/ Work Center II)	Operation Description QC21- Final Inspection	- Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp		
120		Memo		0.00					12	3/6/	10 99		

Quality Control

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DQA:		Date	:		$ \sim$ \sim \sim \sim \sim \sim \sim \sim \sim \sim										
		Б.			WORK ORDER NON	-C	ONFO	RMANCE / UPDATE				AEROSPACE			
QA Closed:		Date	:		<u> </u>		T		W	ork Order u	odate only				
Work Order:					DISPOSITION		AGAINST DEPARTMENT/PROCESS								
					Rework	1	1	Skid-tube Crosstu	_{lbe} [1	Engineering				
Part N	No.				Scrap	1		Machining Small I	· ·	Pro	Water Jet d. Eng. Coor.	Quality			
					Use-as-is	1	Therr	moforming Finish	ing	⊣	re/Packaging	Other			
NCR N	No				Suspected Unapproved]		Large Fab Compos	site]					
			1 .	-		_	<u> </u>								
Root	2			Desc	ription of work order update	1	Initial	Action		Sign &					
Cause	Da	te Step	Qty		or non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector			
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Landir	ng Gear				General		_			_					
	Bendi	ng			Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced			
	Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave				BOM/Route		Grain			Over/Under	tolerance	Set-up			
					Broken/Damage/Defect	L	Hardwa	nre		Part Incorred	ct	Temperature/Cure			
					Burrs	L	Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld			
	Cuffs			<u> </u>	Contamination		₹	tions Incomplete/Unclear	ļ	Part Moved	L	Wrong Stock Pulled			
}	Crush	_		<u> </u>	Countersink	L	4	gned/off center		Positioned V		_			
	Heat			<u> </u>	Cut Too Short	<u> </u>	Mislabe			Power Loss/	Surge	Other			
	_	ction Strip ir	1 Tube	<u> </u>	Drawing	_	Misread					,			
	_	s/Chatter		<u> </u>	Drill Holes	_	Off-set								
}		ng Sequence			Finish	_	4	Calibration							
Wave/Twist in Tube					Fit/Function	I	IOut of 9	Sequence							

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Tuesday, June 04, 2013 2:48:17 PM

Page 1

Work Order ID:

101411

Parent Item:

D2171

Parent Item Name:

Clamp

Start Date: 5/10/2013

Required Date: 5/13/2013

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 11.04.26 now made in house DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2171 Clamp		Manufactured	No	·			Each	17.0000		2	·· · · · · - · · ·		

<u>Location</u>	Loc Qty	Loc Code	
ST456	17		
98008	17		

0 × 27855

DQA:			Date:			$ \sim$ \sim \sim \sim \sim \sim \sim \sim \sim \sim										
QA Closed:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only Work Order update only										
<u> </u>			Dute.													
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS				
<u> </u>						Rework]		Skid-tube	Crosstube		Water Jet	Engineering			
Part N	١٥					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality			
						Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other			
NCR No.				Suspected Unapproved]	Large Fab Composite				Supplier						
Root					Desci	ription of work order update		Initial	Ad	ction	Sign &	<u>-</u>	1			
Cause	D	ate	Step	Qty		or non-conformance	Ch	nief Eng	Desc	cription	Date	Verification	QC Inspector			
Design																
Doc/Data																
Equip/Tooling							1									
Handling/Pre																
Material							ł									
Operator							1									
Offset/Setup]									
Process	_						1									
Supplier		ŀ														
Training																
Transport	_						1									
Unapproved							<u> </u>									
							FA	ULT CAT	regory							
Landir	ng Gear		٠		_	General		1 .		_	7	_	_			
ŀ	Bending				<u> </u>	Bend	_	1	rogram	,	Outside Dim	⊢	Pressure/Forced			
	Centre Not Concentric Cracks					BOM/Route	<u> </u>	Grain		<u> </u>	Over/Under	⊢	Set-up			
					<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa		<u> </u>	Part Incorred	- ⊢	Temperature/Cure			
			c/Ripple,	/Wave	<u> </u>	Burrs	<u> </u>	i '	ion Incomplete/U	` 	Part Lost/Mi	ssing	Weld			
	Cuf				<u> </u>	Contamination	\vdash	4	ions incomplete/		Part Moved	L	Wrong Stock Pulled			
	_	shing			-	Countersink	<u> </u>	1 .	ned/off center	<u> </u>	Positioned V					
		t Treat				Cut Too Short	<u> </u>	Mislabe		L	Power Loss/	Surge	Other			
	Inspection Strip in Tube			<u> </u>	Drawing	<u> </u>	Misread	1								
		rks/Cha			-	Drill Holes	<u> </u>	Off-set								
,		•	quence			Finish		1	Calibration							
	Wave/Twist in Tube					Fit/Function		on Out of Sequence								

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RA 111528

Received @ Dart May 7th, 2013 Inspected@ Dart May 9th, 2013

Customer: SOUL HELICOPTERS Customer Contact: PHIL HANNAH Shipped from: CALGARY AB, CANADA

Instructions for RA 111528

- D2582 B89747 qty x2
 - o Parts have no damage
 - o Return to stock under new BACTH #'s
- D2182B035 B96342 qty x4
 - o Parts have no damage
 - Return to stock under new BACTH #'s
- D2274 B95412 qty x2 & B95118 qty x2
 - o Parts have no damage
 - o Return to stock under new BACTH #'s
- D2171 B94216 qty x2 & B97855 qty x2
 - o Parts have no damage
 - o Return to stock under new BACTH #'s

<u>Time Estimate</u> = 1 HOUR ONLY (stores)

Departments Required: Stores (restocking)

 $\frac{\text{Pictures Attached}}{\text{Pictures Attached}} = \text{NO}$

D2182B035 B96342 qty x4

D2274 B95412 qty x2 & B95118 qty x2 D2171 B94216 qty x2 & B97855 qty x2

THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!